

Work Order ID 63087

Page 1

October 20, 2010 3:10:44 PM

Item ID: D3889-3

Accept



Setup Start



Revision ID:

Item Name: Gasket

Stop



Start Date: 10/20/10 Start Qty: 2.00



Cust Item ID:

Required Date: 10/21/10 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan:

Date: 10/20/10

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr								
----------	--------------	--	--	--	--	--	--	--	--

D3889	A								
-------	---	--	--	--	--	--	--	--	--

100



Waterjet

FLOW CNC Waterjet

Memo

1-Cut as per Dwg D3889

Dwg Rev: AProg Rev: A

2-Deburr if necessary

110



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 63087

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Page 2

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Setup Start



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Start Date: 10/20/10 Start Qty: 2.00



Cust Item ID:

Required Date: 10/21/10 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC

Quality Control

QC8- Inspect parts - second check

0.00

2

10/10/21

130



Packaging

Packaging

Identify as per dwg & Stock Location GA

B63083

0.00

Sb 10/10/21

②

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

10/10/21 JJ

Memo

0.00

MF

10-10-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

October 20, 2010 3:10:43 PM

Page 1

Work Order ID: 63087



Parent Item: D3889-3



Parent Item Name: Gasket

Start Date: 10/20/10

Required Date: 10/21/10

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M4111NS.125		Purchased	No			100	sf	784.7000	3.3053	6.958526			10-10-21

4111 Black Neoprene/EPDM/SBR Blend Sheet 0.125"

Location	Loc Qty	Loc Code
MAT	500	
114937	500	
MAT052	284.7	
112335	284.7	112335

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	63087
Description: Gasket	Part Number:	D3889-3
Inspection Dwg: D3889	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by: <u>RS</u>	Audited by: <u>/</u>	Prototype Approval: N/A
Date: <u>10-10-21</u>	Date: <u>10/10/21</u>	Date: N/A

Rev	Date	Change	Revised by	Approved
A	09.07.29	New Issue	KJ	AA

8

7

6

5

4

3

2

1

D

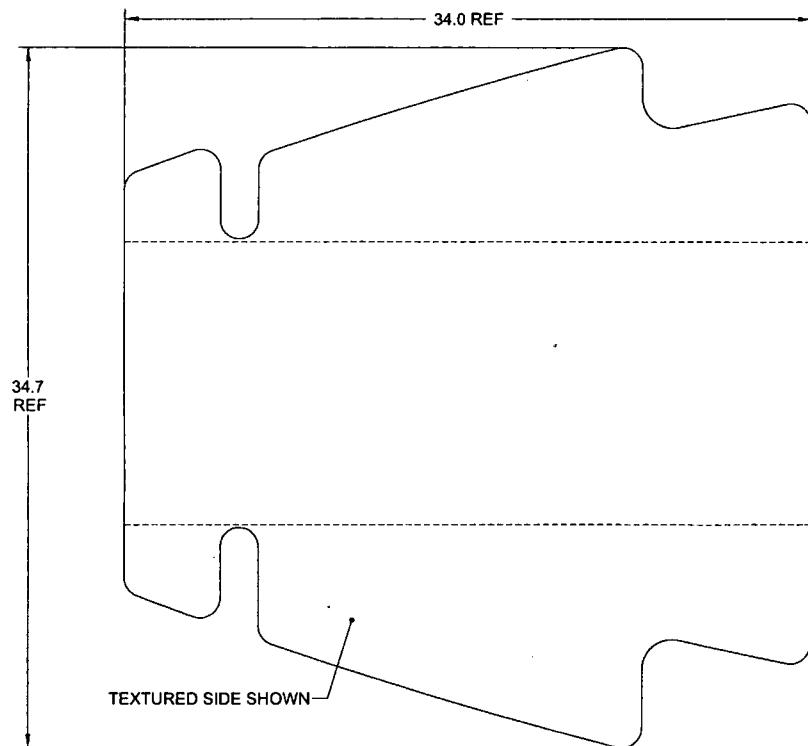
C

B

A

PARTS LIST

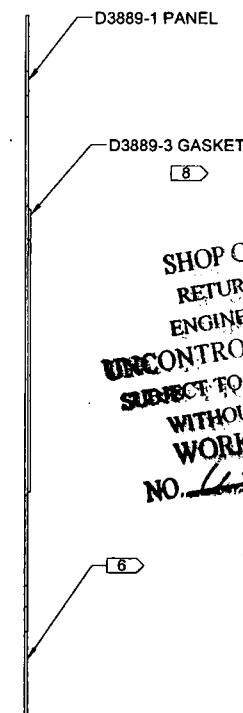
ITEM	QTY	P/N	DESCRIPTION
1	X	D3889-041	PANEL, FLOOR
2	1	D3889-1	PANEL
3	1	D3889-3	GASKET
4	A/R	3M 1300	ADHESIVE



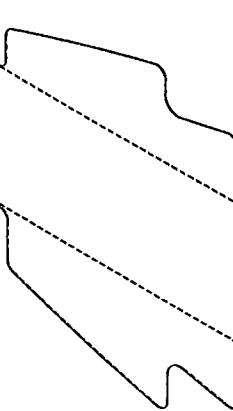
D3889-041 PANEL, FLOOR

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3889-041" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH/UNTEXTURED SIDE OF PART
- 7) WEIGHT: 5.13 lbs
- 8) BOND GASKET TO SMOOTH/UNTEXTURED SIDE OF PART USING 3M 1300 ADHESIVE. TRIM GASKET TO EDGES OF PANEL, IF REQUIRED.

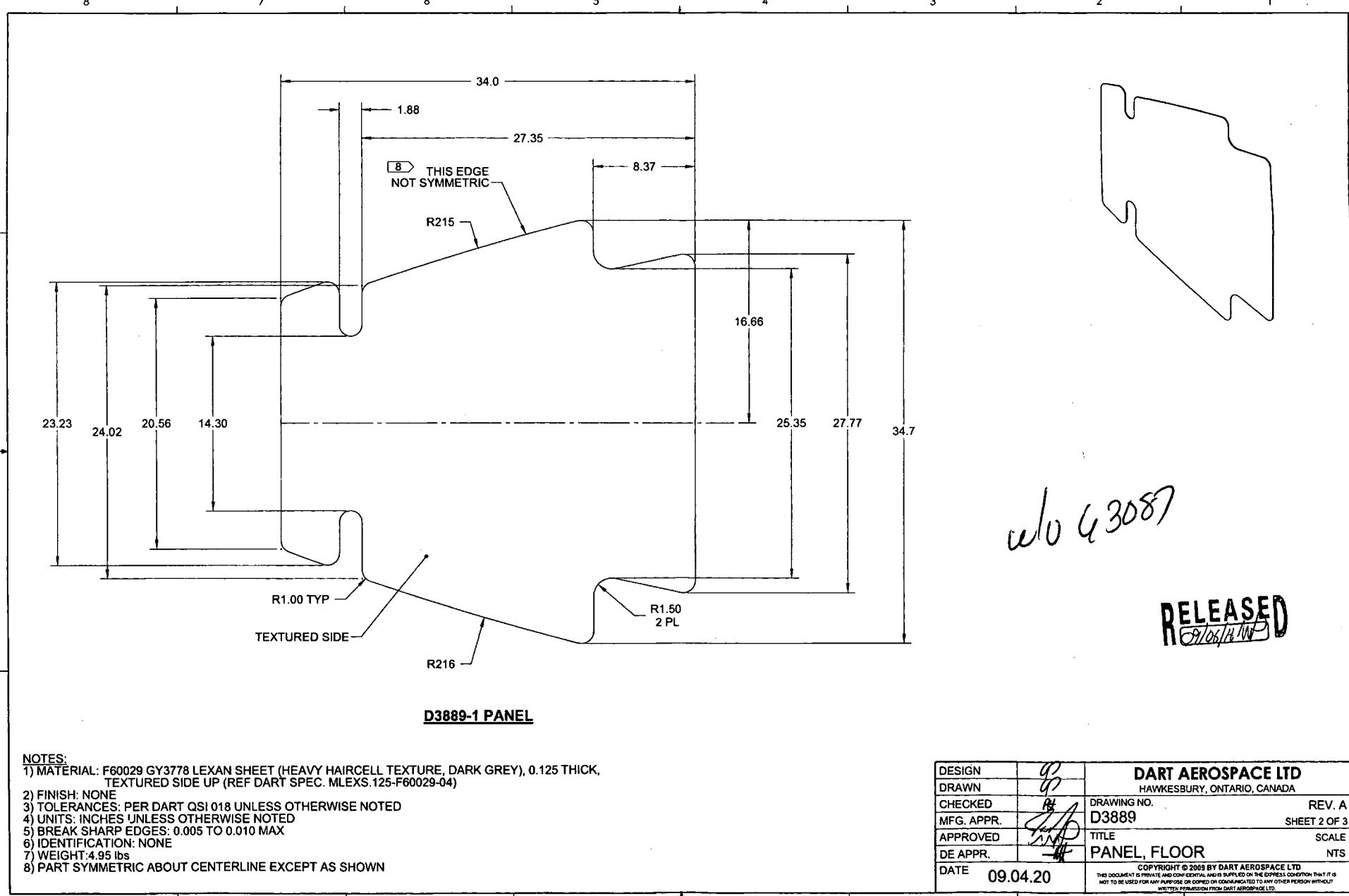


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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 13887
PDI 10-20

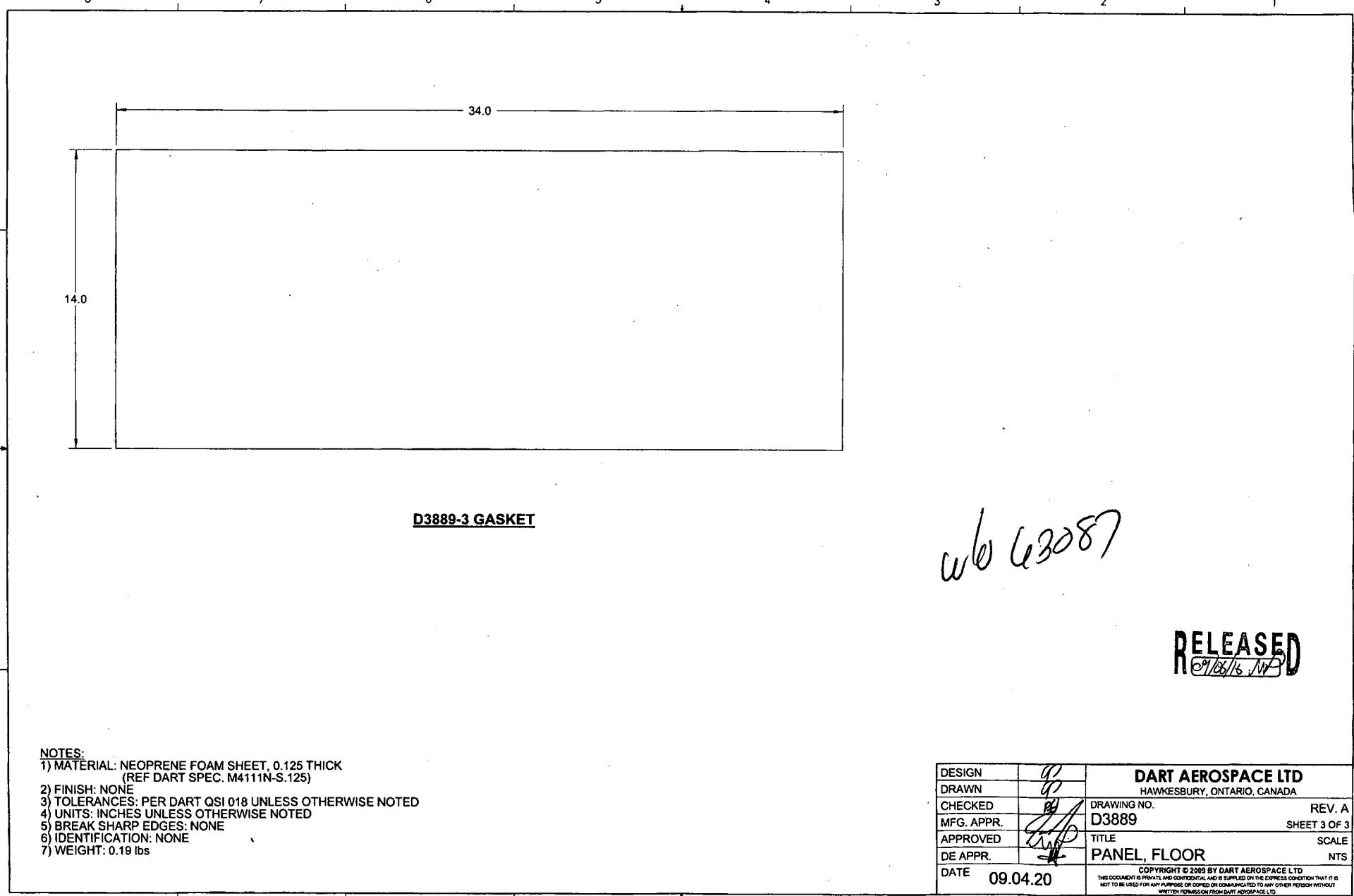


RELEASED
9/16/10 MP

A	NEW ISSUE	CP	09.04.20
REV.	DESCRIPTION	BY	DATE
DESIGN	99	DART AEROSPACE LTD	
DRAWN	99	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AA	DRAWING NO.	REV. A
MFG. APPR.		D3889	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		PANEL, FLOOR	NTS
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DRAWN	<i>99</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>AS</i>	DRAWING NO. REV. A
MFG. APPR.	<i>AS</i>	D3889 SHEET 2 OF 3
APPROVED	<i>AS</i>	TITLE SCALE
DE APPR.	<i>AS</i>	PANEL, FLOOR NTS
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D3889-3 GASKET

WB 63087

RELEASED
09/08/16 M

NOTES:
1) MATERIAL: NEOPRENE FOAM SHEET, 0.125 THICK
(REF DART SPEC. M4111N-S.125)

2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: NONE
6) IDENTIFICATION: NONE
7) WEIGHT: 0.19 lbs

DESIGN	<i>BB</i>	DART AEROSPACE LTD	
DRAWN	<i>BB</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>BB</i>	DRAWING NO. REV. A	
MFG. APPR.	<i>BB</i>	D3889 SHEET 3 OF 3	
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